

Date: Wednesday, 02/04/2008 11:27:18 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, RH
Job Number	: 38293		
Estimate Number	: 10947		
P.O. Number	:	Part Number	: D2480012
This Issue	: 02/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2480 REV A1
First Issue	: / /	Project Number	: N/A
Previous Run	: 38222	Drawing Revision	: A1
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 09/04/2008
Checked & Approved By	: <u>JD 08.04.02</u>	Qty:	3
Comment	: Est. C1 03.01.09 Added Powder Coat	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2478	Lower Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	B38146 ✓

08-04-07 8P

2.0	D2479	Upper Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	B38228 ✓

08-04-07 8P

3.0	D2481	Lower Mount Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	B38147 ✓

08-04-07 8P

4.0	D2482	Upper Mount Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
 Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	B23504 ✓

08-04-07 8P

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:18 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASSY, RH

Job Number: 38293

Part Number: D2480012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

M106762

08-04-07

(3X) SP

6.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 08-04-07 (3)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 08/04/07 (3) R10

8.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107550

08-04-08

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-08 (X3)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 38276

08-04-09 (X3)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



mf 08-04-09

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

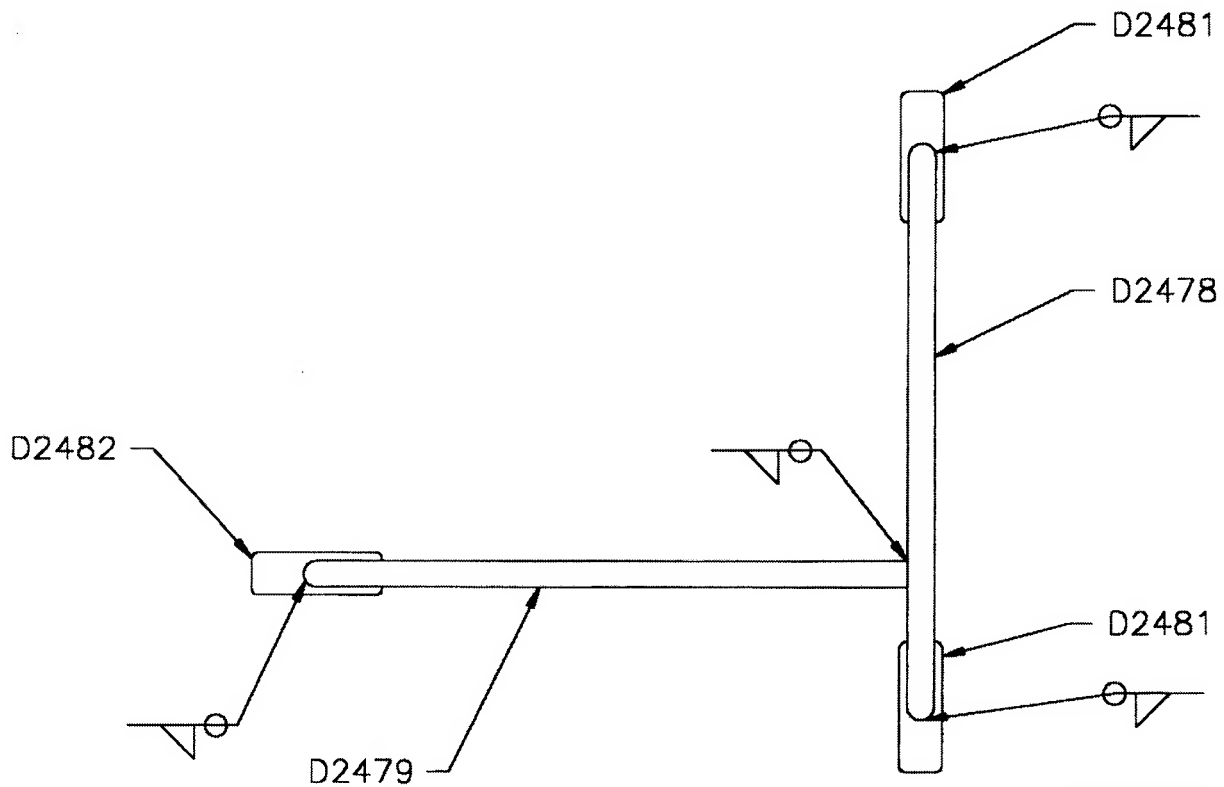
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1 11/10/96 05.06.23		ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38293

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005